Dart Aerospace Ltd.

Date: Thursday, 11/9/2006 4:37:32 PM
User: Kim Johnston

Spec SB 07/01/15

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: BRACKET ASSEMBLY
Job Number	: 29391		
Estimate Number	: 11029		
P.O. Number	: N/A	**Part Number**	: D2803041
This Issue	: 11/9/2006 **S.O. No.** : N/A	**Drawing Number**	: D2803 REV B
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : PURCHASED PARTS	**Drawing Revision**	: B
Previous Run	: 29155	**Material**	: N/A
Written By	:	**Due Date**	: 11/27/2006 **Qty:** 15 **Um:** Each
Checked & Approved By	: SB 06/11/10		
Comment	: EST F 06.03.30 MS21043-3 was MS21042L3 KJ/JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D28031	STA 84 Bracket

Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)
STA 84 BRACKET
Pick:

Qty	Part Number	Description	Batch
1	D2803-1	Bracket	B29403

SEE C/O CHANGE OVER → CP67.01.19

POSITIVE RECALL

2.0	D28051	Stop

Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)
STOP
Pick:

Qty	Part Number	Description	Batch
1	D2805-1	Stop	B30891 x 8 mx.

1-B29405 x 6 mx.

X

3.0	D2809	Bushing

Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s)
Bushing
Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	B30749

Press D2805-1 into arm as per Dwg D2803

X

MF 07-07-17 (14)

4.0	QC5	INSPECT 100% KITS FOR COMPLETENESS

Inspect Level S

Comment: INSPECT 100% KITS FOR COMPLETENESS

ER 07/07/17 (x14) PR

Form: rprocess

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W/O:	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.01.19	1 & 2	USE B/N 29403 FROM QUARANTINE. PRESS FIT D2805-1 STEP IN QTY (1) BRACKET ONLY. GET ENGINEERING DISPOSITION BEFORE CONTINUING	SB 07/07/16	07/07/16	+1	07.01.19 DV QA 07/07/16	07/07/16
07.07.17	4	permanent change				07-07-17	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/9/2006 4:37:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BRACKET ASSEMBLY

Job Number: 29391 **Part Number:** D2803041

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	POWDER COATING	POWDER COATING

M101575

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 BK/M-07-07-17 (14)

6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION SAM 07/07/18 (14)

7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Press D2809 into arm as per Dwg D2803 SAM 07/07/18 (14)

8.0	AN3C16A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)
Bolt
Pick:

Qty	Part Number	Description	Batch
2	AN3C16A	Bolt	M102760 (25) M101884 (3)

9.0	MS210433	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 30.0000 Each(s)
Nut
Pick:

Qty	Part Number	Description	Batch
2	MS21043-3	Nut	M104679

10.0	NAS1515H3	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 60.0000 Each(s)
Washer
Pick:

Qty	Part Number	Description	Batch
4	NAS1515H3	Washer	100993
A/R	LPS-3	Corrosion Spray	M104929

Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803 SAM 07/07/18 (14)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: ☐ Date: 07/07/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/9/2006 4:37:32 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** BRACKET ASSEMBLY

Job Number: 29391 **Part Number:** D2803041

Job Number:

Seq. #:	Machine Or Operation:	Description :
11.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D2803.	SAD 07/07/18 (14)
12.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	EM 07/07/18 counted (+14)
13.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_____	7/7/19 SP (14)
14.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	07.07.19

Job Completion

EL 07.07.19

POSITIVE RECALL
EFFECTIVE 07.08.19 AUTH GP
RELEASED 07.07.19 DATE GP

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

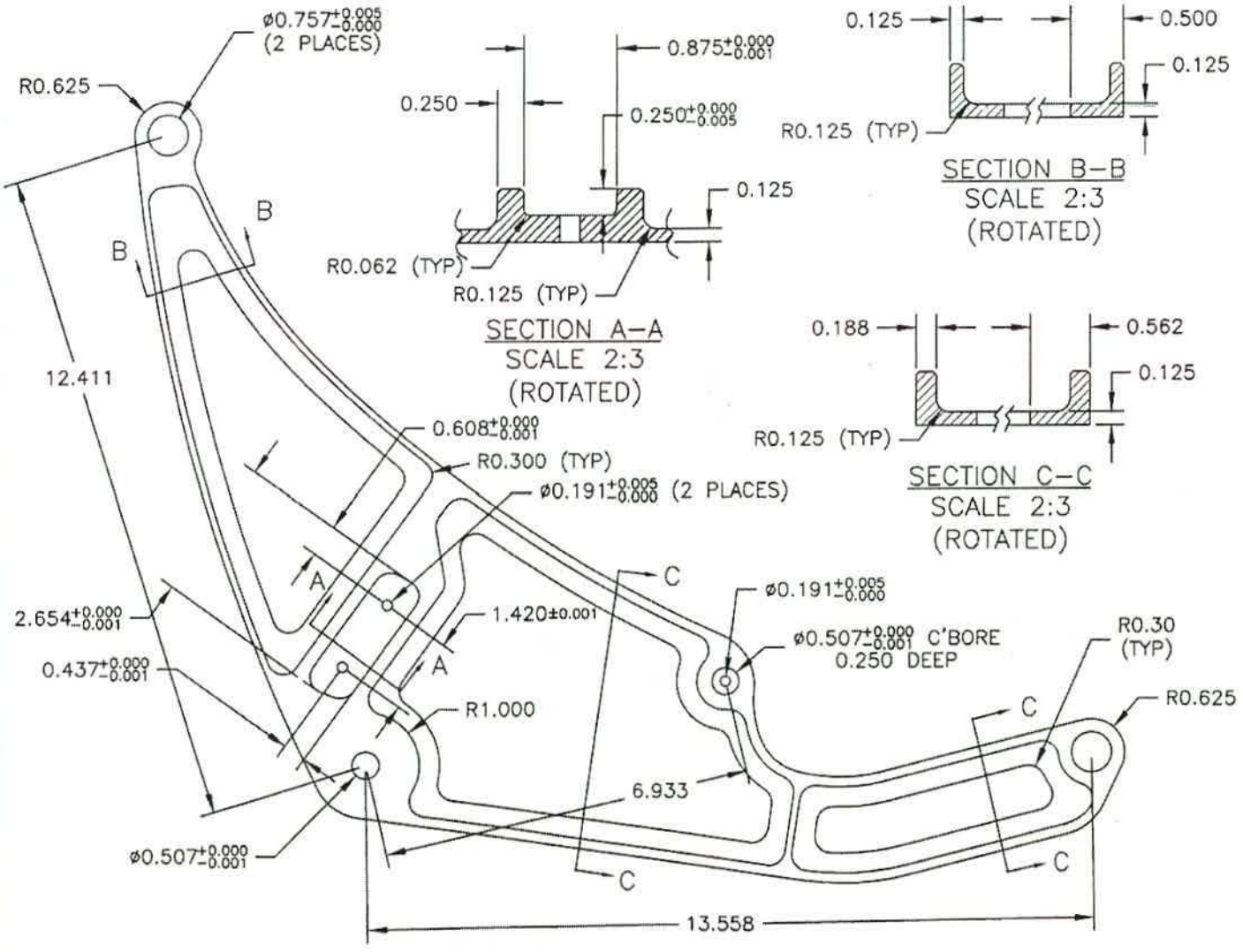
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CP	CP		
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2803	SHEET 1 OF 2
DATE		TITLE	SCALE
04.11.22		STA 84 BRACKET	1:3

A	00.11.07	NEW ISSUE
B	04.11.22	ADD CUTOUTS & -043/-044

RELEASED
05.03.11



SECTION A–A
SCALE 2:3
(ROTATED)

SECTION B–B
SCALE 2:3
(ROTATED)

SECTION C–C
SCALE 2:3
(ROTATED)

D2803–1 BRACKET (SHOWN), D2803–2 BRACKET (OPPOSITE)

1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
2) MATERIAL: 6061–T6 (QQ–A–200/8) OR (QQ–A–250/11) 0.500 THICK
3) DEBURR TO LEAVE R0.030 – 0.063 ON ALL EDGES
4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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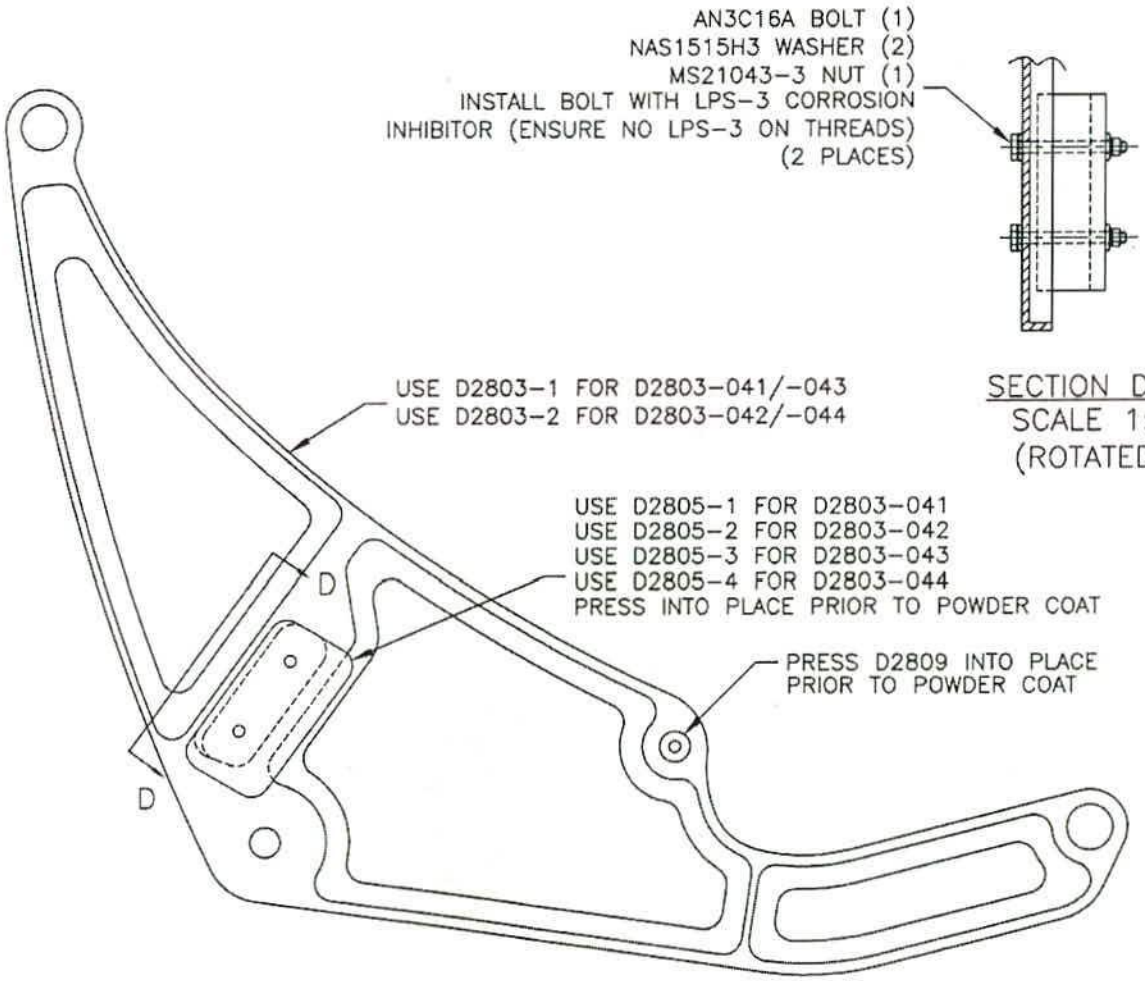
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29391

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CP	CP		
CHECKED	APPROVED	DRAWING NO.	REV. B
		D2803	SHEET 2 OF 2
DATE		TITLE	SCALE
04.11.22		STA 84 BRACKET	1:3



SECTION D-D
SCALE 1:3
(ROTATED)

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

RELEASED
05-03-11

WORK ORDER
NO. 29391

D2803-041/-043 BRACKET ASS'Y (SHOWN),
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

Chris Provencal

From: David Shepherd [dshepherd@dartaero.com]
Sent: January 19, 2007 11:02 AM
To: 'Chris Provencal'
Subject: RE: D2803 Bracket

Yes. Proceed as you have outlined below.

David

From: Chris Provencal [mailto:cprovencal@dartaero.com]
Sent: Thursday, January 18, 2007 2:04 PM
To: David Shepherd (David Shepherd)
Subject: D2803 Bracket

D2803 bracket for the folding steps:

The pockets for the stop should be 0.875+0.000/-0.001 wide to fit a 0.875+0.001/-0.000 wide D2805 stop.

The pockets now (qty 13) are 0.872, so there would be an extra 0.002 of press fit. They said they should be able to re-machine, but they aren't too keen on doing so (mainly from the time it would take). I suspect there's also a danger of scrapping them if they mess something up in the re-machine.

I am thinking that we could try press fitting them regardless (we'd try try just one first!). We'd have to make sure the holes still allow the AN3 bolts to pass through. Would you accept this deviation if the press fit is acceptable?

-Chris